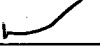


Date: Thursday, 10/08/2006 10:04:37 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEBBING TIDY
Job Number : 28144	
Estimate Number : 11381	
P.O. Number : N/A	Part Number : D32153
This Issue : 10/08/2006 S.O. No. : N/A	Drawing Number : D3215 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : C
Previous Run : 27757	Material : N/A
Written By : 	Due Date : 31/08/2006 Qty: 80 Um: Each
Checked & Approved By : _____	
Comment : Est. A04.01.06 New issue KJ/RF Est Rev:B Now on Waterjet 06-07-03 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M5052H32S040	5052-H32 .040 Sheet
-----	--------------	---------------------



Comment: Qty.: 0.0271 sf(s)/Unit Total : 2.1672 sf(s)

5052-H32 .040 Sheet

Material: 5052-H32 (QQ-A-250/8) 0.040" thick
 (M5052H32S.040)

Identify for D3215-3A

Batch: M17835

0.008 sf

5052-H32 .040 sheet

batch: M15982


812

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3215

Dwg Rev: 

Prog Rev: C

2-Debur if necessary

+ Cut 2.130" x 0.530"

Deburr - M.F. 06-08-15

M.F. 06/08/11

SAD 06-08-11

81

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 06-08-11

81

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

06-08-15 81

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: AS Date: 06/08/29
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/08/16	5	2 piece were out of tolerance	AS	Scrap - destroy	SS 06/08/16	AS 06/17	N/A	AS 06/17

NOTE: Date & initial all entries

Date: Thursday, 10/08/2006 10:04:37 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEBBING TIDY

Job Number: 28144

Part Number: D32153

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE
Form D3215-3A as per Dwg D3215

SB 06/08/16

(79)

6.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP.

06-08-17

79

7.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1
Weld D3215-3 by joining D3215-3A and D3215-3B as per Dwg D3215 and QSI 004
A/R AL ROD BATCH: M/8838

Identify as D3215-3
Grind flush

ELC 06-08-21 (79)

8.0	QC5/9	WELD INSPECTION
-----	-------	-----------------



Comment: WELD INSPECTION

06/08/22 (79)

9.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

D.M 06-08-23

(79)

10.0	POWDER COATING	POWDER COATING
------	----------------	----------------



Comment: POWDER COATING
Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

DL 06/08/23 (79)

11.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
------	-----	---



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06/08/23 (79)

12.0	PACKAGING 1	PACKAGING RESOURCE #1
------	-------------	-----------------------








Comment: PACKAGING RESOURCE #1

STAIL

ID + stack

06/08/23 (79)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
06-08-17	5.1	- Shear D3215-3B .530X2.130 using SOS2-H32.040 AS per Dwg. Batch# <u>M15982</u> - deburr AS necessary	M.F.	06-08-17	11	 Approved	 06-08-17	
06-08-17	5.1	Add step AS shown. Permanent change 	E	06-09-05		 Approved	 06-08-17	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: Date: 06/08/06
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/08/2006 10:04:37 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEBBING TIDY

Job Number: 28144

Part Number: D32153

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

u 06.08.24

Job Completion



u 06.08.24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

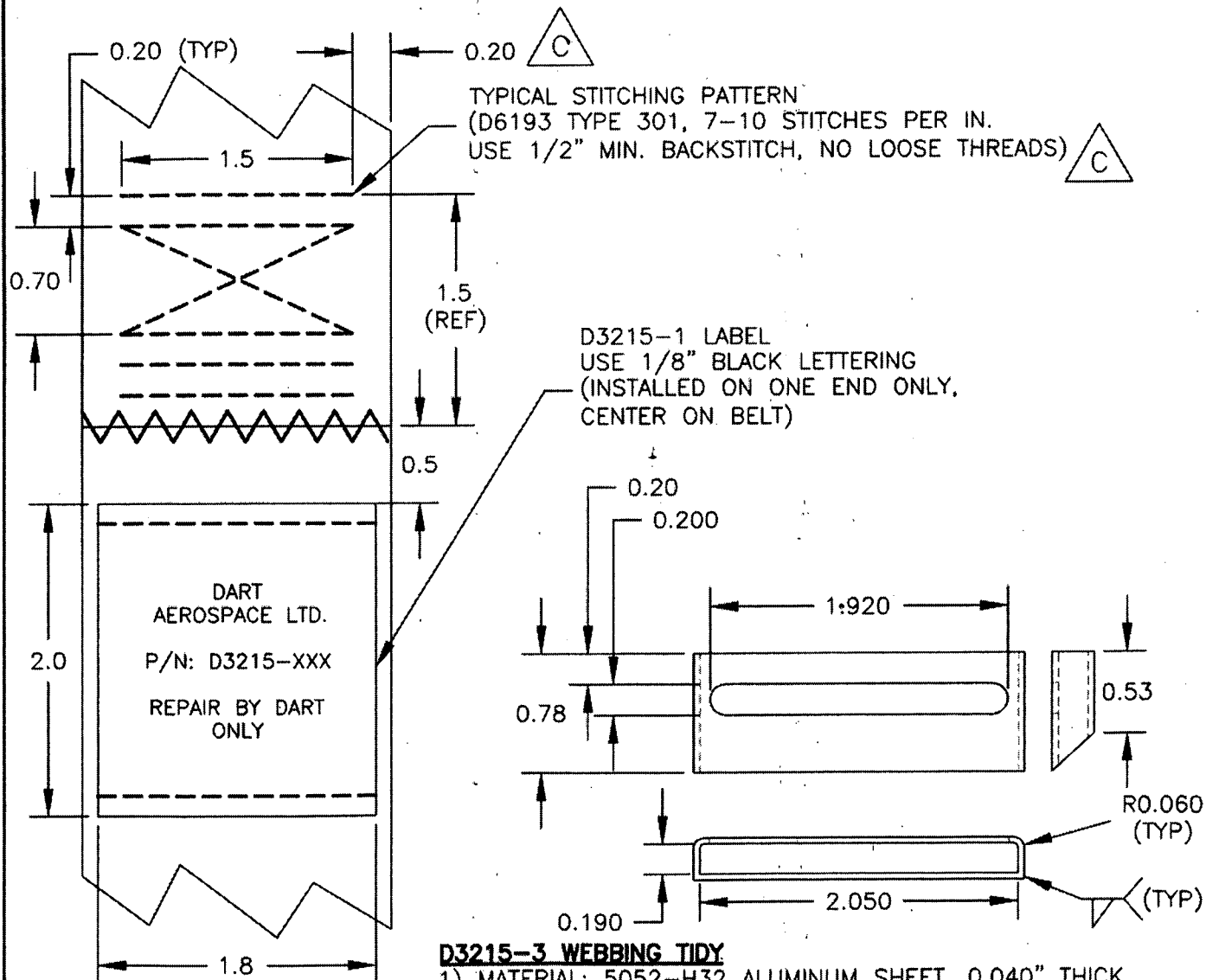
NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>AF</i>	APPROVED <i>AF</i>	DRAWING NO. D3215	REV. C SHEET 3 OF 3
DATE 04.03.05		TITLE HARNESS ASSEMBLY	SCALE 1:1

VIEW A-A

XXX = 041 FOR D3215-041
XXX = 043 FOR D3215-043



RELEASED
04.03.05

D3215-3 WEBBING TIDY

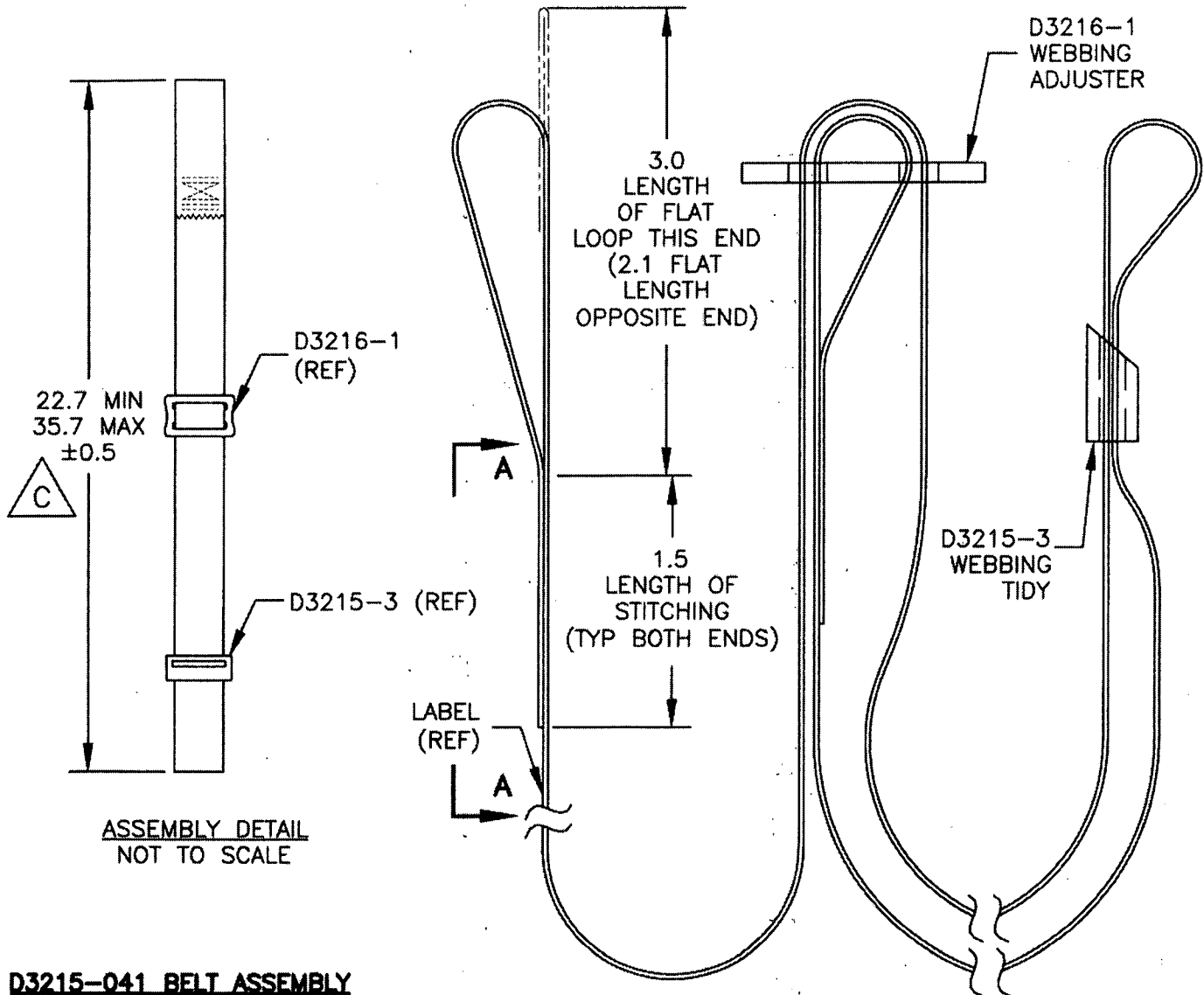
- 1) MATERIAL: 5052-H32 ALUMINUM SHEET, 0.040" THICK
(REF DART SPEC. M5052H32S.040)
- 2) WELD PER DART QSI 004
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER
DART QSI 005 4.3.
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE
NOTED

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DART

DESIGN	AP	DRAWN BY	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO. D3215
DATE	04.03.05	TITLE	BELT ASSEMBLY	REV. C SHEET 1 OF 3
				SCALE NTS
A	03.09.19	NEW ISSUE		
B	04.01.12	AS MANUFACTURED; ADD TOLERANCE		
C	04.03.05	REDUCE LENGTH; CLARIFY STITCHING		

RELEASED
04 03 08**D3215-041 BELT ASSEMBLY**

- 1) MATERIAL: WEBBING = LAGRAN CANADA INC. 26472
(2" WIDE x 0.060" THICK BLACK POLYESTER WEBBING, CERTIFIED
TO FAR 29.853A3, TENSILE STRENGTH 5700 lb MIN)
THREAD = VT 295 TYPE II CLASS A SIZE 3, BLACK NYLON THREAD
LABEL = TYVEK

2) ALL DIMENSIONS ARE IN INCHES

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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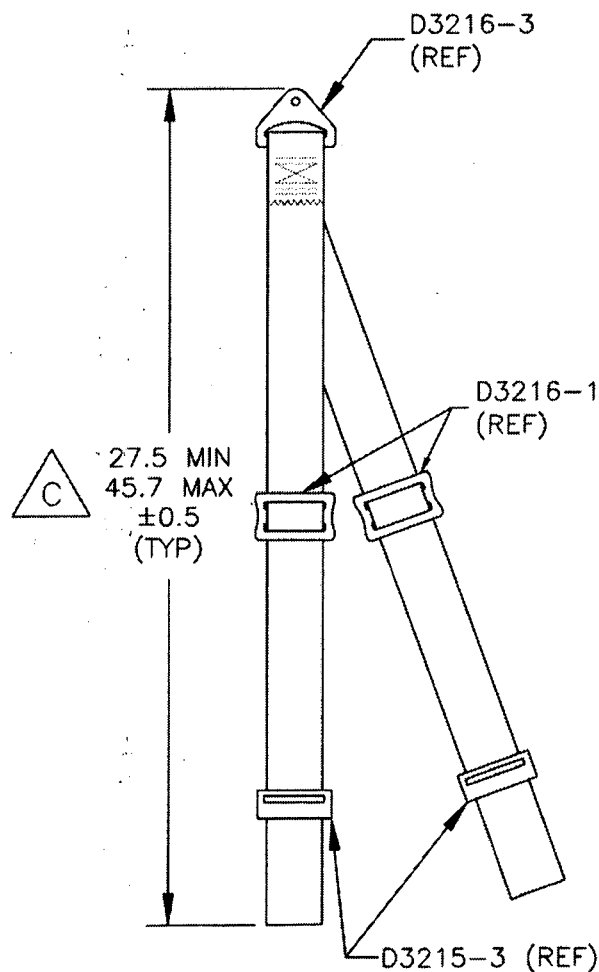
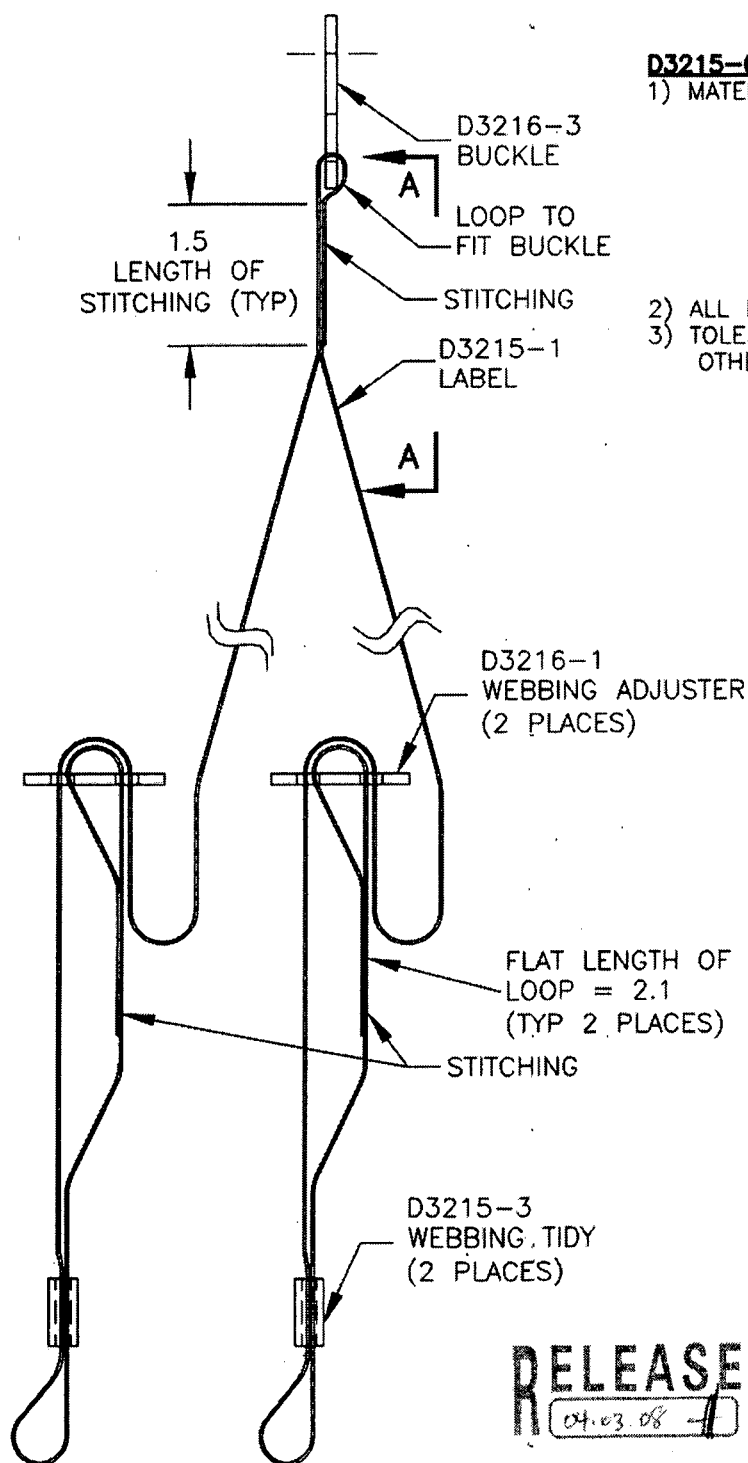
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DESIGN P	DRAWN BY P	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3215	REV. C SHEET 2 OF 3
DATE 04.03.05		TITLE BELT ASSEMBLY	SCALE NTS

D3215-043 BELT ASSEMBLY

- 1) MATERIAL: WEBBING = LAGRAN CANADA INC. 26472
(2" WIDE x 0.060" THICK
BLACK POLYESTER WEBBING,
CERTIFIED TO FAR 29.853A3,
TENSILE STRENGTH 5700 lb MIN)
THREAD = VT 295 TYPE II CLASS A SIZE 3,
BLACK NYLON THREAD
LABEL = TYVEK
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED.



RELEASED
04.03.08

ASSEMBLY DETAIL
NOT TO SCALE

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